

(SPLIT) 3

Work Order ID 52129-2

September 16, 2009 2:31:04 PM



Page 1

Item ID: D2917-2

Accept



Setup Start



Revision ID: B

Item Name: Saddle RH

Stop



Start Date: 09/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-09-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2917

Rev B

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program batch number ☐ Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

mf 09/10/06
SP 09/10/05
mf 09/10/06
SP 09/10/05
mf 09/10/06
SP 09/10/05

3 *✓*
3 *✓*
3 *✓*

Picklist Print

September 16, 2009 2:31:04 PM

Page 1

Work Order ID: 52129



Parent Item: D2917-2RevB



Parent Item Name: Saddle RH

Start Date: 09/30/2009

Required Date: 10/05/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	6.0000	10.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6

51423

6

52067

8/29/10/05

3

DART AEROSPACE LTD		Work Order: 52129
Description: Saddle RH		Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.195	.197	.192	.195		
B	0.090	0.110		.095	.100	.100	.100		
C	0.250	0.270		.265	.267	.262	.267		
D	1.599	1.619		1.614	1.615	1.610	1.614		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.285	.284	.288	.284		
G	1.385	1.400		1.391	1.395	1.390	1.390		
H	3.170	3.230		3.200	3.200	3.200	3.200		
I	0.175	0.217		.187	.184	.191	.191		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.503	1.503	1.503	1.503		
L	4.436	4.446		4.438	4.438	4.438	4.438		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.228	1.228	1.228	1.228		
O	1.103	1.113		1.106	1.106	1.106	1.106		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		.508	.502	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.200	.200	.205	.200		
W	1.990	2.010		2.000	2.008	2.004	2.003		
X	0.760	0.765		.760	.760	.761	.761		
Y	0.307	0.312		.310	.310	.311	.311		
Z	0.615	0.635		.628	.624	.625	.625		
AA	0.177	0.197		.185	.185	.184	.185		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SP</i>
Date: 09/10/05

Audited by: <i>mf</i>
Date: 09/10/06

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	<i>SP</i>

DART AEROSPACE LTD	Work Order: 52129
Description: Saddle RH	Part Number: D2917-2
Inspection Dwg: D2917 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	4		
A	0.175	0.205		.136	.177	.196			
B	0.090	0.110		.100	.110	.110			
C	0.250	0.270		.258	.262	.263			
D	1.599	1.619		1.610	1.610	1.614			
E	0.180	0.220		.184	.180	.181			
F	0.277	0.297		.286	.285	.285			
G	1.385	1.400		1.390	1.392	1.393			
H	3.170	3.230		3.200	3.200	3.200			
I	0.175	0.217		.191	.175	.175			
J	0.470	0.530		.500	.500	.500			
K	1.498	1.508		1.503	1.503	1.503			
L	4.436	4.446		4.440	4.440	4.440			
M	0.257	0.262		.259	.259	.259			
N	1.225	1.235		1.230	1.230	1.230			
O	1.103	1.113		1.108	1.108	1.108			
P	0.470	0.530		.500	.500	.500			
Q	0.438	0.443		.440	.440	.440			
R	0.490	0.510		.500	.510	.605			
S	1.745	1.755		1.750	1.749	1.750			
T	7.990	8.010		8.00	8.000	8.000			
U	3.495	3.505		3.500	3.499	3.500			
V	0.175	0.205		.204	.205	.205			
W	2.000	2.020		2.000	2.004	2.000			
X	0.760	0.765		.760	.760	.760			
Y	0.307	0.312		.310	.311	.311			
Z	0.615	0.635		.625	.626	.628			
AA	0.177	0.197		.184	.185	.186			
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SK</i>
Date: <i>09/09/05</i>

Audited by: <i>MMF</i>
Date: <i>09/19/07</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	09.09.14	Revised dimension W	KJ	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 52129
Description: Saddle RH	Part Number: D2917-2
Inspection Dwg: D2917 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.190	.190	.190			
B	0.090	0.110		.090	.093	.090			
C	0.250	0.270		.268	.267	.267			
D	1.599	1.619		1.617	1.617	1.617			
E	0.180	0.220		.180	.180	.180			
F	0.277	0.297		.292	.292	.293			
G	1.385	1.400		1.388	1.388	1.388			
H	3.170	3.230		3.190	3.191	3.191			
I	0.175	0.217		.177	.179	.180			
J	0.470	0.530		.500	.500	.500			
K	1.498	1.508		1.499	1.503	1.503			
L	4.436	4.446		4.440	4.440	4.440			
M	0.257	0.262		.259	.259	.259			
N	1.225	1.235		1.227	1.226	1.229			
O	1.103	1.113		1.105	1.106	1.108			
P	0.470	0.530		.500	.500	.500			
Q	0.438	0.443		.440	.440	.440			
R	0.490	0.510		.502	.503	.504			
S	1.745	1.755		1.756	1.749	1.750			
T	7.990	8.010		8.006	8.003	8.001			
U	3.495	3.505		3.500	3.500	3.500			
V	0.175	0.205		.205	.205	.205			
W	2.000	2.020		2.002	2.000	2.001			
X	0.760	0.765		.760	.760	.760			
Y	0.307	0.312		.311	.311	.311			
Z	0.615	0.635		.624	.626	.625			
AA	0.177	0.197		.185	.186	.185			
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>mf</i>
Date: 09/10/06

Audited by: <i>mf</i>
Date: 09/10/07

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	09.09.14	Revised dimension W	KJ	

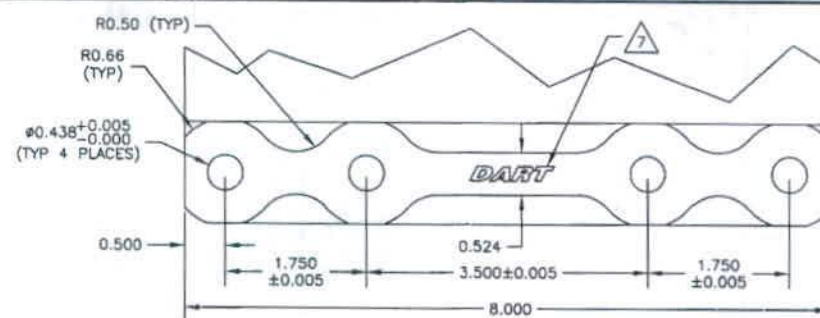
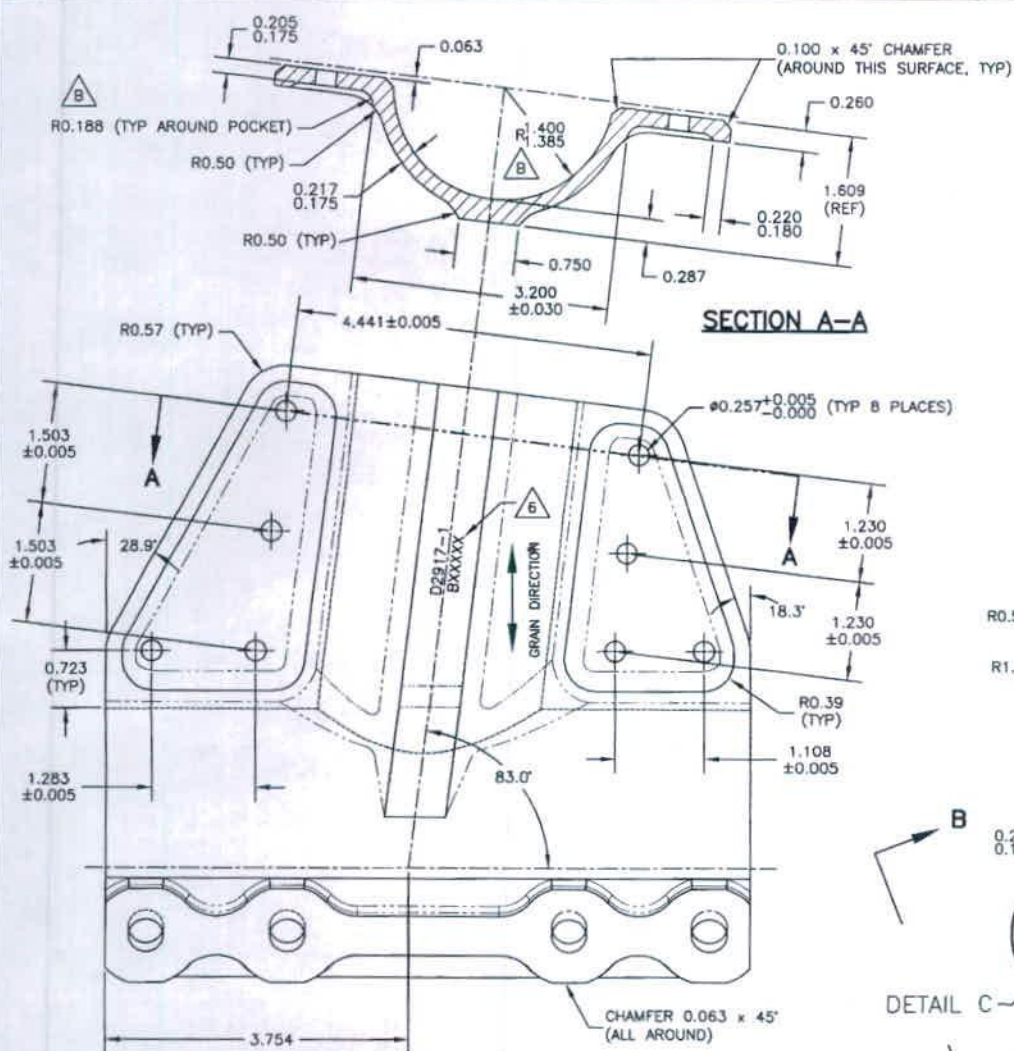
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

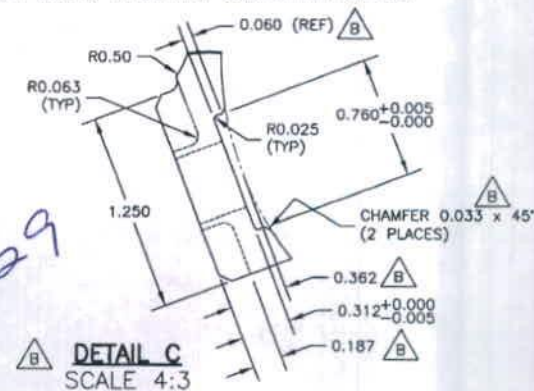
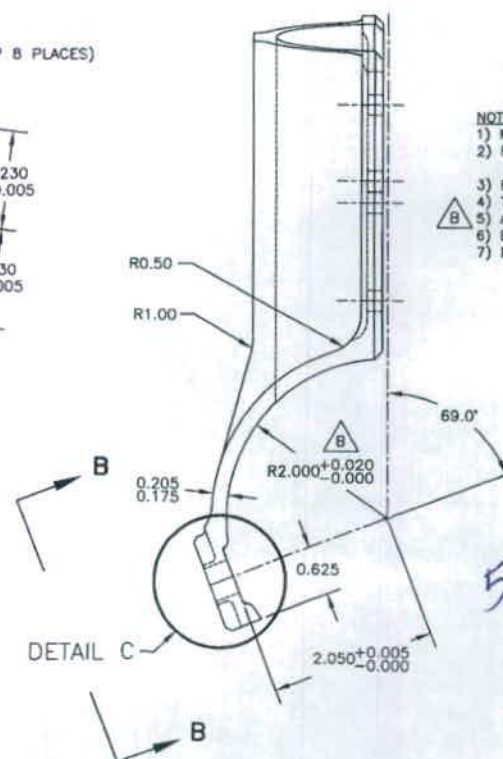
NOTE: Date & initial all entries



D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



RELEASED

07.07.31

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B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.06.26	DRAWING NO. D2917
		TITLE SADDLE
		REV. B SHEET 1 OF 1 SCALE 2:3

DART DART AEROSPACE LTD.
HAMPSHIRE, ENGLAND, CANADA

